

Work Order ID **77476*****77476***

Page 1

December-08-11 11:18:22 AM

Item ID: D3442-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 08/12/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 14/12/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/12/08 Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3442

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3442 Dwg Rev: B Prog Rev: B 2-

Deburr if necessary

B11-12-14304 .037

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-12-14

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 11/12/1410

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77476

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December-08-11 11:18:22 AM

Item ID: D3442-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Shim
 Start Date: 08/12/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 14/12/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging	*****STOCK IN BASKET CELL*****								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

11/12/14 9x

11/12/19

11-12-14
(a)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 77476

77476

Parent Item: D3442-3

D3442-3

Parent Item Name: Shim

Start Date: 08/12/2011

Required Date: 14/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP A05.09.02New issueKJ/JLM

IPP B 07.07.23 waterjet EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S22GA

Purchased

No

100

sf

86.3600

0.025

0.105263

**

B11-12-14

M304S22GA

304/316 .032 Sheet

Location

Loc Qty

Loc Code

MAT020

86.36

109057

3.3

117379

7.06

118271

73

118400

3

118400

9

W/O:		WORK ORDER CHANGES					
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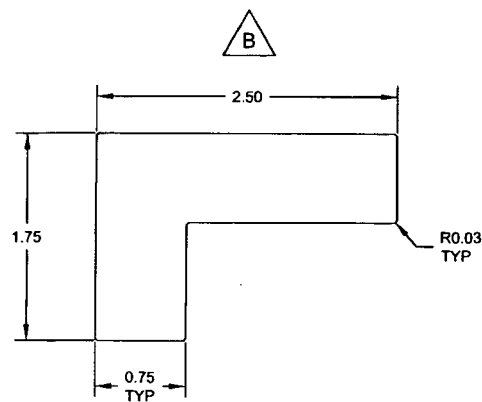
8 7 6 5 4 3 2 1

D

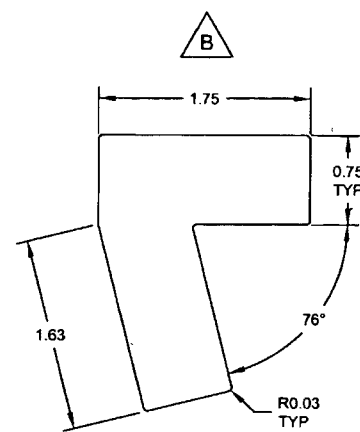
C

B

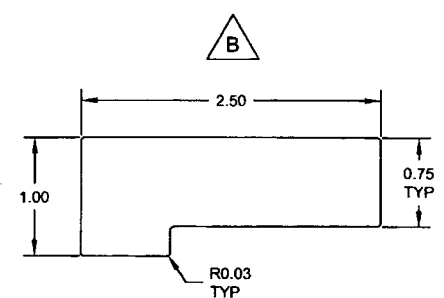
A



D3442-1 SHIM



D3442-3 SHIM



D3442-5 SHIM

SHO COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33476 M.L.J

11/12/08

RELEASED
2011-05-30

NOTES:

- 1) MATERIAL D3442-1/-3: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 22 GAUGE (0.031 THICK) REF. DART SPEC. M304S22GA
- D3442-5: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 16 GAUGE (0.063 THICK) REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs APPROX



B	REFORMAT. MATERIAL FOR -1 & -3 WAS 21 GAUGE. TOLERANCE UPDATED FOR ALL PARTS. (SEE PAR 10-005)	AJS	11.05.26
A	NEW ISSUE	PH	05.06.03
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JE	DRAWING NO.	REV. B
MFG. APPR.	JE	D3442	SHEET 1 OF 1
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	SHIM	NTS
DATE	11.05.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

A

8 7 6 5 4 3 2 1

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